

Date: Friday, 2/23/2007 1:49:40 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT TUBE ASSEMBLY
Job Number	: 30934		
Estimate Number	: 10699		
Part Number	: <i>NIA</i>	Part Number	: D3391025
Issue	: 2/23/2007 S.O. No. : <i>NIA</i>	Drawing Number	: D3391 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NIA</i>	Drawing Revision	: E
Previous Run	: 30933	Material	: <i>NIA</i>
Written By	:	Due Date	: 3/21/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	1 Um: Each
Comment	Est Rev B 06-02-07 ECN773 dwg rev. D EC Est Rev C 06-03-28 Update Manufacturing Instructions JLM		

Additional Product

Job Number:



Seq. #.	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	D6014090	ALUMINUM EXTRUSION
-----	----------	--------------------



Comment: Qty.: 1.0000 f(s)/Unit Total: 1.0000 f(s)
 ALUMINUM EXTRUSION
 Pick:
 Qty Part Number Description Batch
 1 D6014-090 Extrusion *B26546*
 Identify as D3391-3

BF 07/03/09

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE
 Turn as per Folio FA599 Rev: *11* & Dwg D3391 Rev: *E*

BC 07/03/09

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BC 07-03-10 (1)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS
 1-Machine as per Folio FA 599 Rev: *11* & Dwg D3391 Rev: *E*
 2-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803
 3-Deburr

*CP 07/03/10**PTO.*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/12	# 4.0	API hole is off by 0.008" on the short side. (0.392" not 0.400"). operator didn't drill correctly.	07/04/02 05/04/12	Part acceptable.	Enp 07/03/12	07/04/02	05/04/02	07/04/02

NOTE: Date & initial all entries

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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 30934

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 07/03/12 (1)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/03/15 (1)

7.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

EL 7-4-2

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-4-2

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391

5-Deburr

DP 7-4-2

Tools: rill

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-04-02

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

07-04-02 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 30934

Part Number: D3391025

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 POWDER COATING POWDER COATING



M103706



①

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L

07/04/02

13.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



ml 07 04 02



①

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0 NAS1330C3KB166 INSERT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
8	NAS1330C3KB166	Insert	M103278

07-04-03

15.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per dwg

07-04-03

16.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0 AESS10KB366 INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Insert

Pick:

Qty	Part Number	Description	Batch
14	AESS10KB366	Insert	M103758

07-04-03

18.0 AESS10KB266 INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
2	AESS10KB266	Insert	M17905

or NAS1330C3KB266

07-04-03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 30934

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AESS10KB316

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
2	AESS10KB316	Insert	M17905
	or NAS1330C3KB316		

HL 07-04-03 (D)

20.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	B30119

B30119

21.0

AN3C4A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C4A	Bolt	M103691

M103691

22.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	M103691

M103691

23.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	M103691

M103691

HL 07-04-03 (D)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/05

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 30934

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291

Sikaflex expiry date:

N1103497
07/10

258 07.04.04

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Signature

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

B30309
PPP P 7/4/4

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①

07/04/05

Job Completion



U 07.04.04

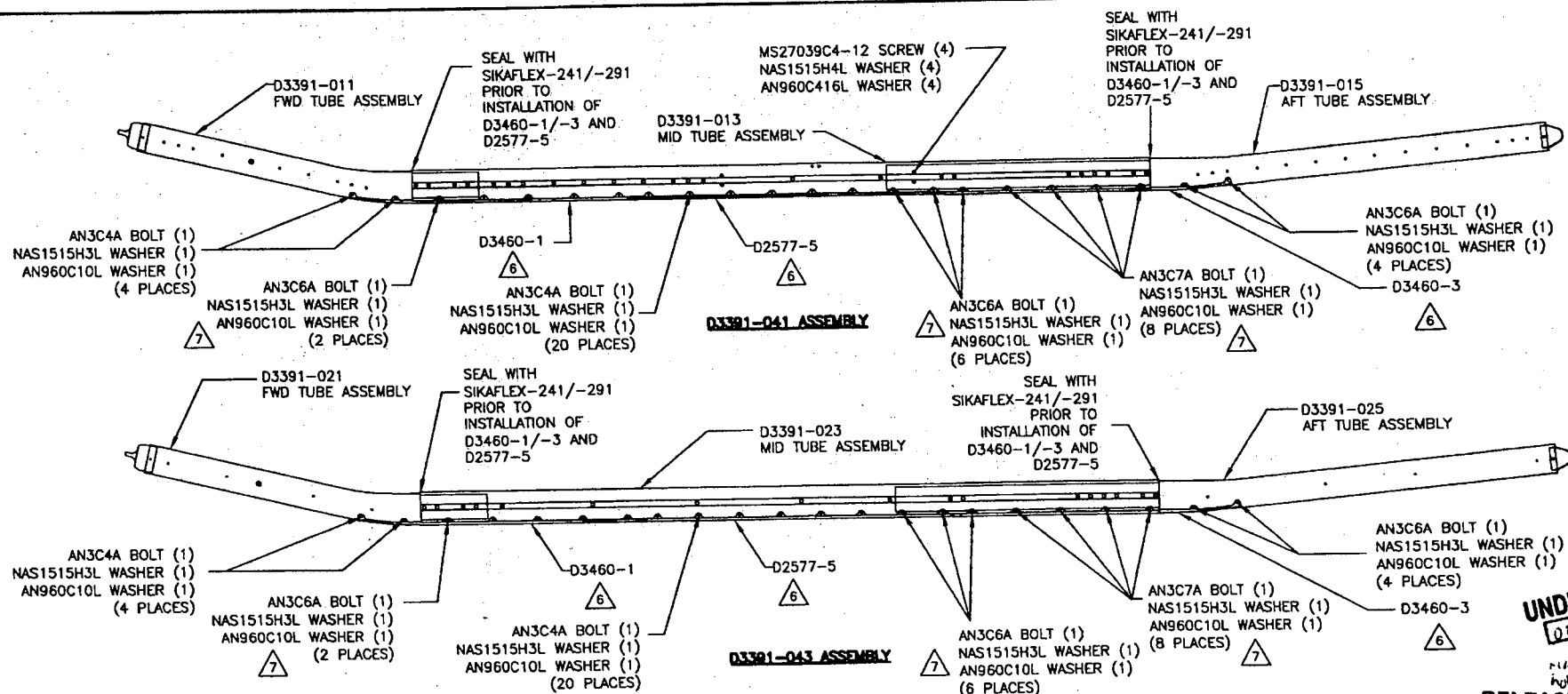
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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



GENERAL NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL "E" SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS.
- 6) C/SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 7) APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	NAS1515H3L	WASHER
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
1		D2577-5	WEARSHOE
1	1	D3460-1	WEARSHOE
1	1	D3460-3	WEARSHOE

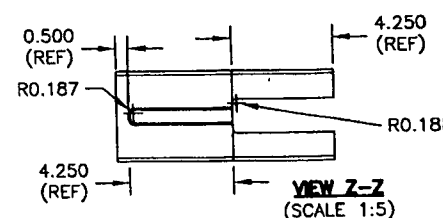
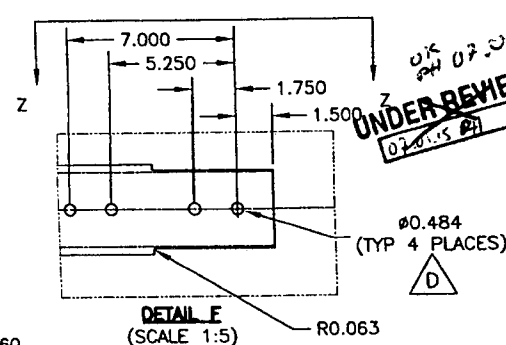
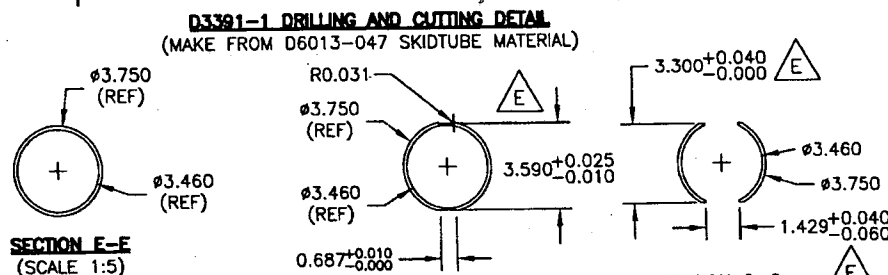
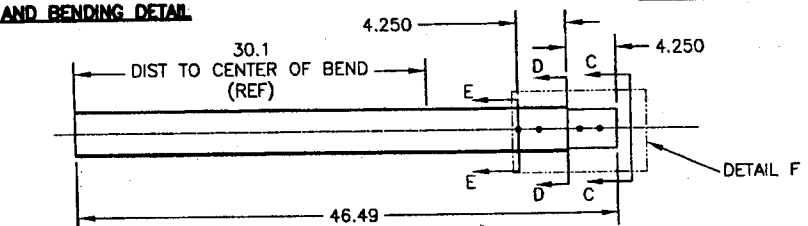
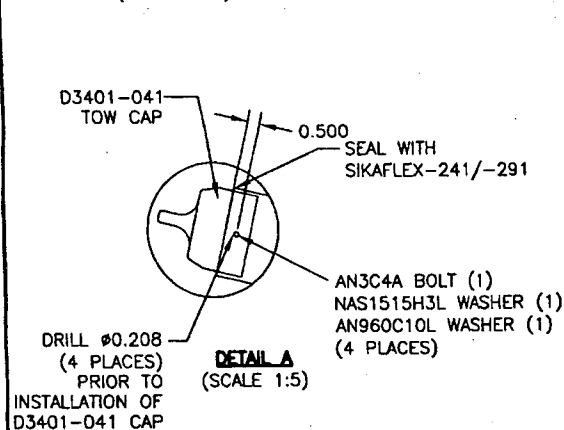
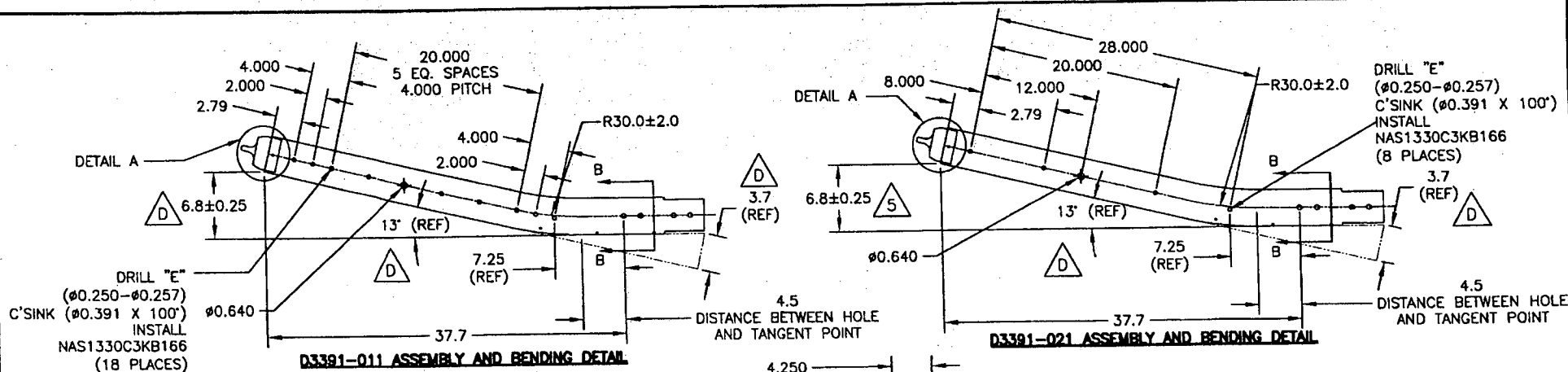
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RETURN TO
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NO. 30934
SUBJECT TO AMENDMENT
WITHOUT NOTICE

UNDER REVIEW
06.02.03
06.05.03

RELEASED

E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DART AEROSPACE USA, INC.
DRAWN BY	PH	PORT HADLOCK, MA
CHECKED	*	DRAWING NO. D3391
APPROVED	*	REV. E
DATE	06.04.25	SHEET 1 OF 5
TITLE	412 FLOAT SKIDTUBE	SCALE
		NTS

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D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

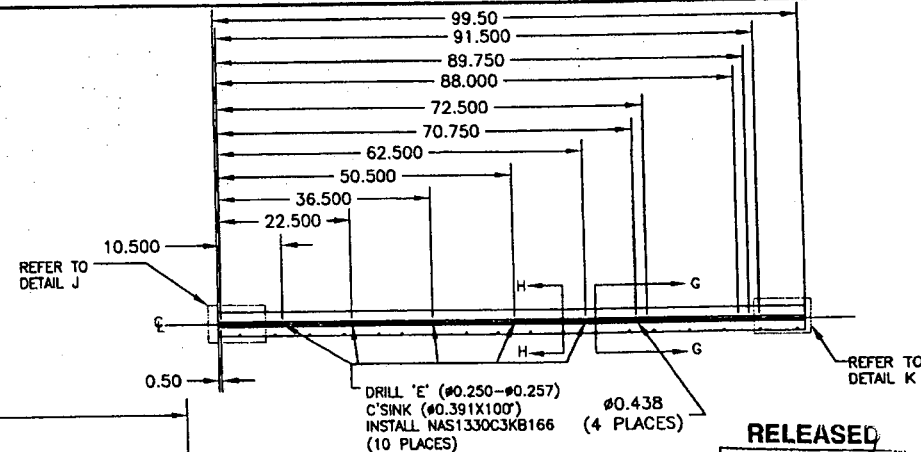
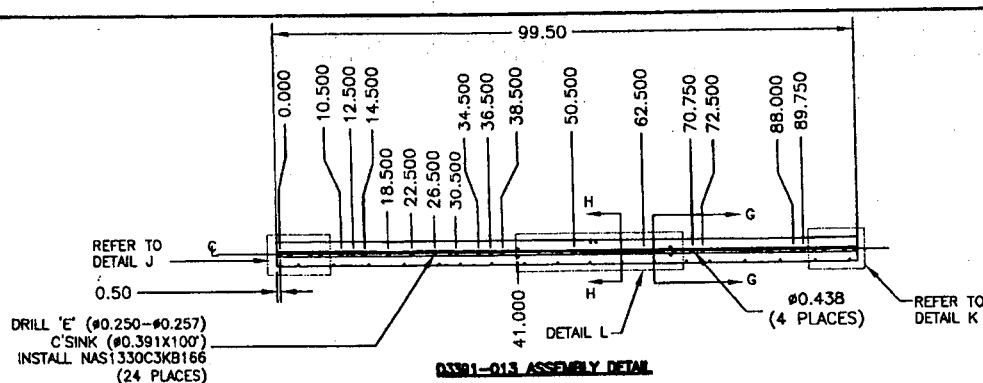
QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
4	4	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER
24	14	NAS1330C3KB166	INSERT

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WORK ORDER
30134

DESIGN PH PH DART DART AEROSPACE USA, INC.
CHECKED PH APPROVED PH DRAWING NO. D3391
DATE 06.04.25 TITLE 412 FLOAT SKIDTUBE
REV. E SHEET 2 OF 5 SCALE 1:10

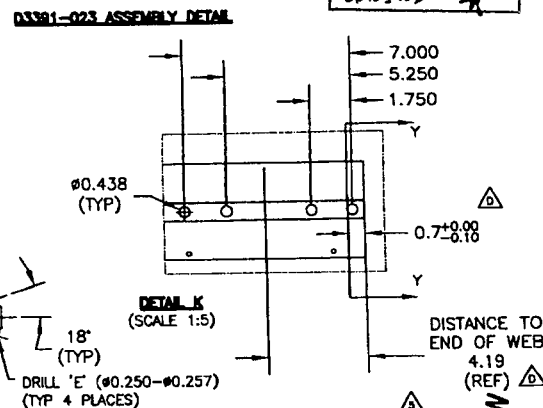
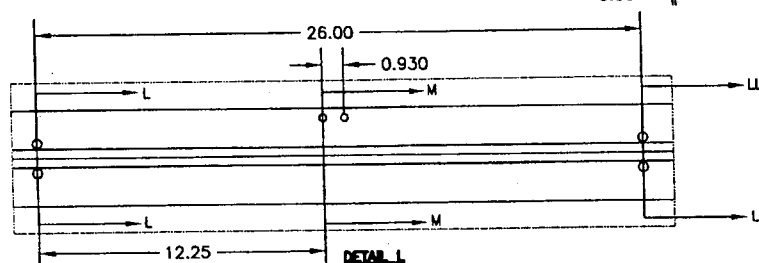
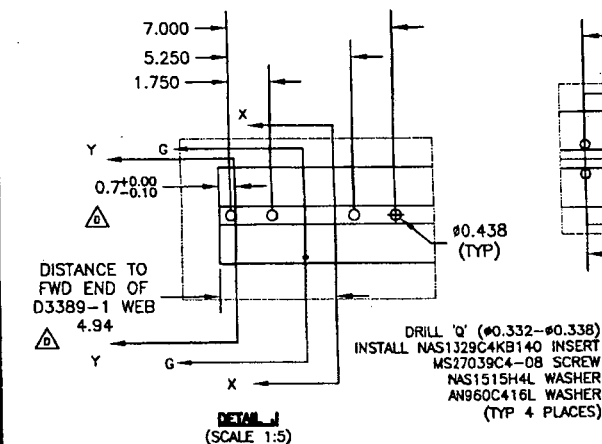
OK PH 07.02.07
UNDER REVIEW
07.01.05 PH

RELEASED
06.05.03

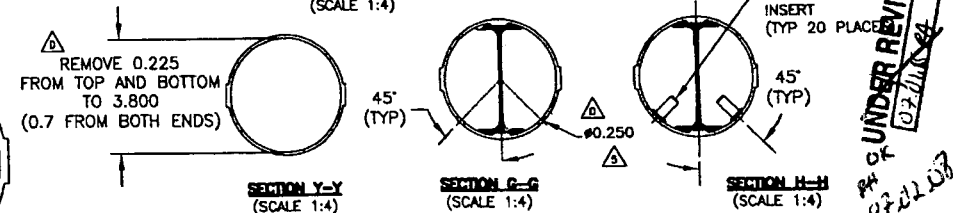
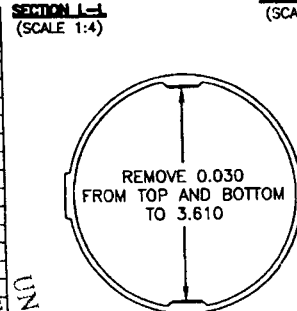


RELEASED

06-05-01



QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X		D3391-013	MID TUBE ASSEMBLY
	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330C3KB116	INSERT
24	10	NAS1330C3KB166	INSERT
4		NAS1329C4KB140	INSERT
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

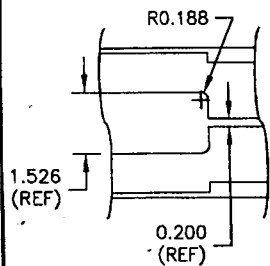


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PH	PH	PH	PH	
CHECKED	APPROVED	DRAWING NO.	REV. E	
		D3391	SHEET 3 OF 5	
DATE	TITLE	SCALE		
06.04.25	412 FLOAT SKIDTUBE			1:20

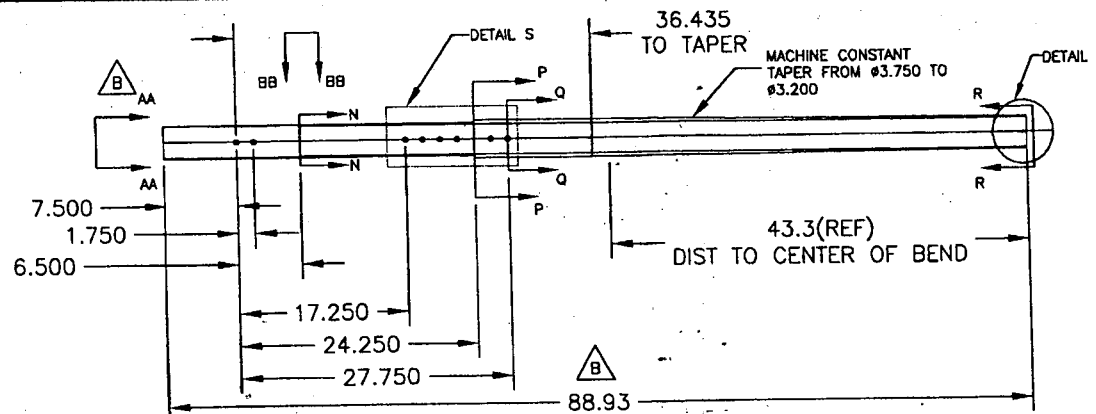
D3391-013/-023 MID TUBE ASSEMBLY
1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER OSI 015

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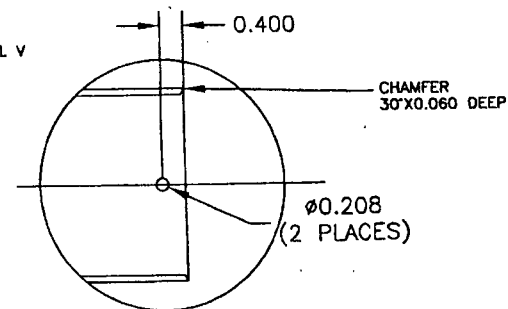
UNDER REVIEW
07/11/04
07/21/03



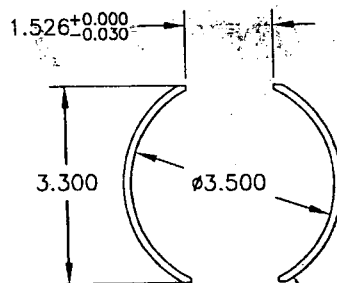
VIEW BB-BB
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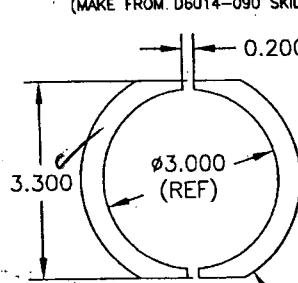
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



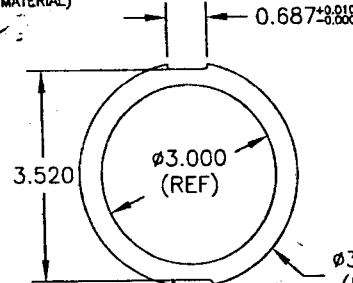
DETAIL V
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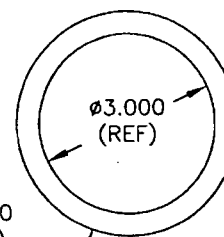
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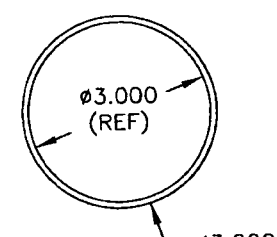
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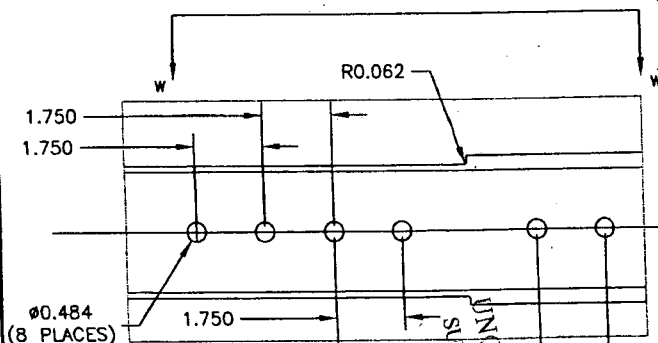
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(SCALE 1:2)



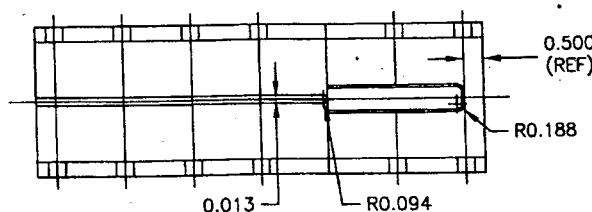
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)



VIEW W-W
(SCALE 1:3)

08 RH 07.02.07
UNDER REVIEW
07.01.07

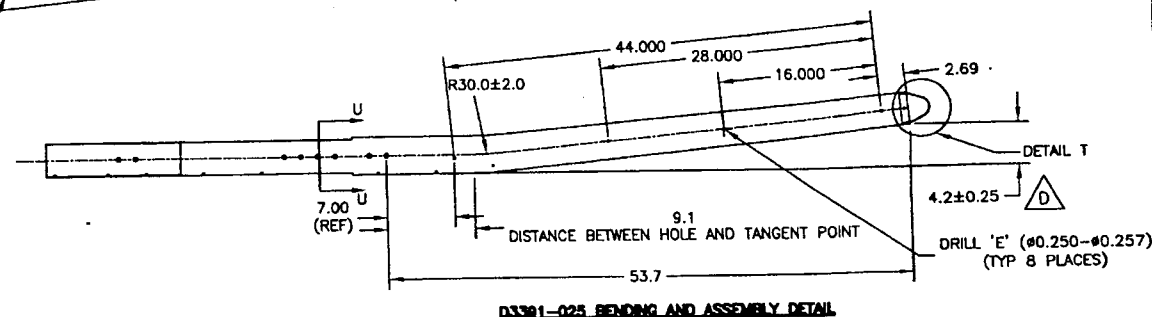
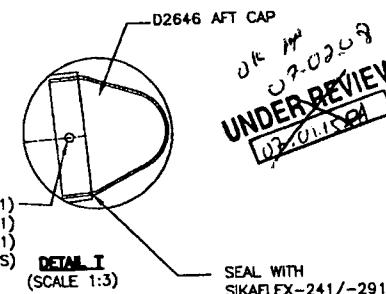
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205.03

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PH		PH	PH	PORT HADLOCK, MA	
CHECKED		APPROVED		DRAWING NO.	REV. E
DATE		06.04.25		D3391	SHEET 4 OF 5
TITLE		412 FLOAT SKIDTUBE		SCALE	1:12

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NO. 20134
WORK ORDER
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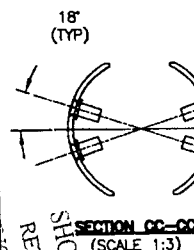


HC	ES MARKED	QTY D6381-315	CTY D3391-026	C'SINK	P/N
C81		18	14	0.0425	AESS10K3666
C82	✓			0.0391	AESS10K3666
C83	✓		2	0.0391	NAS1350C3KE316
C84	✓		2	0.0391	NAS1350C3KE266
C85	✓			0.0391	NAS1350C3KE216
C86		12	8	0.0391	NAS1350C3KE166

Technical drawing of a beam assembly. The drawing shows a long, thin beam with several components labeled: CS1, CS3, CS4, and CS6. A dimension line indicates a length of 0.332 to 0.338 inches. A note specifies '1/4" (10.520X100)'. A 'RELEASED' stamp is visible, dated '06-05-03'. The drawing is titled '03301-025 INSERT INSTALLATION DETAIL (SEE TABLE)'.

QTY - 016	QTY - 025	PART NUMBER	DESCRIPTION
X		D3361-015	AFT TUBE ASSEMBLY
	X	D3361-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
16	14	AESS10KB366	INSERT
4	2	NA91330C3KB318	INSERT
4	2	NA51330C3KB268	INSERT
4		NA51330C3KB216	INSERT
12	8	NA51330C3KB168	INSERT
4		NA51330C4KB151	INSERT
2	2	AN3C4A	BOLT
2	2	NA51515H3L	WASHER
2	2	AN960C10L	WASHER

UNCONT
SUBJECT
NO.



DRILL 'Q' (#0.332-#0.338)
C'SINK (#0.529X100#)
NAS1330C4KB151 INSERT (1)
(4 PLACES)

DESIGN	DRAWN BY	DART	DART AEROSPACE USA, INC. PORT HANCOCK, WA
PH	PH		
CHECKED	APPROVED	DRAWING NO. D3391	REV. E SHEET 5 OF 5
DATE 06.04.25	TITLE 412 FLOAT SKIDTUBE		SCALE 1:1

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DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO.	REV. E
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D3391	SHEET 5 OF 5
FILE	SCALE

412	FLOAT SKIDTUBE	1:12
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DART AEROSPACE LTD		Work Order: 36934
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.500	✓			
88.93	+/-0.030	88.93	✓			
44.995	+/-0.030	45.0	✓			
3.200	+/-0.010	3.210	✓			
1.526	+0.000/-0.030	1.526	-			
0.200	+/-0.010	0.203	-			
7.500	+/-0.010	7.501	✓			
27.750	+/-0.010	27.750	✓		Tape Measure	
31.750	+/-0.010	31.750	✓		Tape Measure	
35.250	+/-0.010	35.250	✓		Tape Measure	
X 0.400	+/-0.010	0.382		-		
X Ø0.208	+0.005/-0.001					
3.300	+/-0.010	3.305	✓			
0.200	+/-0.010	0.203	✓			
3.520	+/-0.010	3.520	✓			
0.687	+0.010/-0.000	0.687	-			
R0.062	+/-0.010	0.062	✓			
Ø0.484	+0.005/-0.001	0.484	-			

Measured by: J. S. IBC	Inspected by:	Prototype Approval:	N/A
Date: 6/7/03	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	

